Cup 5th

Work Order ID 111537

111537

Page 1

January-15-14	1:17:30 PM										
Item ID: Revision ID:	D3575-6		A	Accept	*N900	040	100)* s	Setup Star	17	S1*
Item Name:	Cargo Floor Pr	rotector							Stop	, *N	S2*
Start Date:	1/15/14	Start Qty: 1.00	*1*		Cust Item	ID:					
Required Date:	: 1/15/14	Req'd Qty: 1.00	*1*		Customer:						
Reference:		_	•								
Approvals:	Process Pla	n: MMLS	Date: 14-01-16	Tooling:	D	ate:		R	Run Star	^IV	R1*
	QC:		Date:	SPC (Y/N): _	D	ate:			Stop	, *N	R2*
Sequence ID/ Work Center I	D .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr		-							
D3575	Rev	A									
100		·		0.00							
100		FLOW WATER JET							٥		Jm 14-02-
Waterjet		Memo		0.00							
FLOW CNC Water	jet	1-Cut as per Deburr if ne	Dwg D3575 Dwg Rev: cessary	A Prog Rev: A	_ 2-						
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
110	•							1	٥		Jm14-02-3
QC		Memo		0.00					,		
Quality Control											
				DAS 27							
120		QC8- Inspect parts - seco	ond check	0.00 9 89				i			
120 QC Quality Control		Memo		0.00 Mlal3							

DQA:			Date:						_					DT.
						WORK ORDER NON	-CC	ONFO	RMANCE / UP			–	AEROS	PACE
QA Closed:			Date:							W	ork Order up	date only		
Work Order	•					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS		
WOIR Oluci	· -					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering	وا
Part No) .					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	_
	_					Use-as-is	1	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other	r
NCR No	o					Suspected Unapproved]		Large Fab	Composite		Supplier]	
0	_				Daga	inting of mode and a malata	-	nitial	Acti	on.	Sign 9		•	
Root		Data	Cham	O+1.	Desci	ription of work order update or non-conformance			•		Sign & Date	Verification	QC Inspec	ctor
Cause	+	Date	Step	Qty		or non-comormance		ief Eng	Descri	ption	Date	Vermeation	QC IIIspec	2101
Design Doc/Data	\dashv						ļ							
Equip/Tooling	┨										1	:		
Handling/Pre	┨												:	
Material	┨								[]			
Operator	┪											- -		
Offset/Setup	┪						Ì							
Process	٦												1	
Supplier	٦												1	
Training														
Transport														
Unapproved		=												
							FA	ULT CA	TEGORY					
Landing	g G	ear				General	_	,		_	_	_	_	
	-	Bending			<u> </u>	Bend	\vdash	1	Program	_	Outside Dim	-	Pressure/Force	ed
	⊣	Centre No	ot Concer	ntric		BOM/Route	L	Grain			Over/Under	-	Set-up	
	-	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa		_	Part Incorre	 -	Temperature/	Cure
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		4 '	ion Incomplete/Un	· -	Part Lost/Mi	ssing	Weld	
L	\neg	Cuffs				Contamination	<u></u>	-	tions Incomplete/U	Inclear	Part Moved	L	Wrong Stock F	² ulled
<u> </u>	_	Crushing			<u> </u>	Countersink	\vdash	4	gned/off center		Positioned V		٦	
	_	Heat Trea				Cut Too Short	-	Mislabe		L	Power Loss/	Surge	Other	
	\neg	Inspection	-	lube	-	Drawing	-	Misrea						
-	_	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set			·			
	_	Turning S	•		_	Finish	-	4	Calibration					
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence					

Work Order I	\mathbf{D} 1	11:	537
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111537

Page 2

January-15-14 1:17:36 PM Item ID: D3575-6 Accept *N900040100* Setup Start **Revision ID: Item Name:** Cargo Floor Protector *1* **Start Date:** Start Qty: 1.00 1/15/14 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 1/15/14 *1* **Customer:** Reference: Run Process Plan: Date: **Tooling: Approvals:** Date: Stop SPC (Y/N): QC: Date: Date: Sequence ID/ Reject Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 0.00 Small Fab *130* Small Fab Memo Small Fab Deburr innecessary. QC5- Inspect part completeness to step on W/O 140 0.00 *140* OC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 150 0.00 *150* POPILISIO **Packaging** Memo Packaging

DQA:			Date:												
						WORK ORDER NON-	-CC	NFO	RMANCE / UP	DATE			_		AEROSPACE
QA Closed:			Date:							1	Νo	rk Order up	date only		
						DISPOSITION				AGAINST [DEF	PARTMENT	PROCESS		
Work Orde	er: _						. 1		cut a sub a	C	\neg		Mater let	_	Engineering .
0	• -					Rework			Skid-tube	Crosstube Small Fab	\dashv	Dro	Water Jet d. Eng. Coor.	\dashv	Engineering Quality
Part N	10.					Scrap Use-as-is			Machining noforming	Finishing	ᅥ		re/Packaging	\dashv	Other
NCR N	lo.					Suspected Unapproved		men	Large Fab	Composite		nec/stol	Supplier	ㅓ	
WCIV I	٠٠.					Suspected Onapproved	1		curge rub	Composite				_	
Root					Desc	ription of work order update		nitial	Acti	on		Sign &			<u>'</u>
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	ļ	Date	Verification		QC Inspector
Design			,	•						· · · · · · · · · · · · · · · · · · ·					
Doc/Data											l				
Equip/Tooling							Į							-	
Handling/Pre															
Material											-				
Operator							1		ļ						
Offset/Setup														ı	
Process									[
Supplier														ļ	
Training															
Transport															
Unapproved															
							FA	ULT CA	TEGORY	<u></u>	-				
Landi		1				General	_	1 ,,	_	г	_	l	. г	_	D /5
		Bending			-	Bend	-	t	Program	ŀ		Outside Dim	-	\dashv	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	\vdash	Grain		}-		Over/Under	-		Set-up
	_	Cracks	L /D: L		-	Broken/Damage/Defect	-	Hardwa			↤	Part Incorre	- t-	-	Temperature/Cure Weld
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		4 .	ion Incomplete/Un		_	Part Lost/M	issing	\dashv	
	\vdash	Crushing				Contamination Countersink	\vdash	4	tions Incomplete/U gned/off center	riclear		Part Moved Positioned V	Vrong L		Wrong Stock Pulled
	-	Crushing Heat Trea			\vdash	Cut Too Short	\vdash	Mislab	_	}	$\overline{}$	Positioned v		\neg	Other
	\vdash	Inspectio		Tubo		Drawing	\vdash	Misrea		Ĺ		I OMEL FOSS	Juige [Olici
	\vdash	Marks/Ch	•	iune	-	Drill Holes	\vdash	Off-set							
	\vdash	Turning S				Finish	-	4	Calibration						
	-	Wave/Tw				Fit/Function		4	Sequence						

Work Ord	er ID	111537
January-15-14	1:17:36	PM
Item ID:	D3575-0	5

Quality Control

111507

Page 3

January-15-14	1:17:36 PM	,			1:3:21								
Item ID: Revision ID:	D3575-6			Accept	*N900	040	100)* s	etup S	Start	*N!	S1*	
Item Name:	Cargo Floor	Protector								Stop	*N!	S2*	
Start Date:	1/15/14	Start Qty: 1.00	*1*		Cust Item 1	ID:							
Required Date	: 1/15/14	Req'd Qty: 1.00	*1*		Customer:								
Reference:			•										
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:		R		Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:			:	Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	
160		QC21- Final Inspection	Work Order Release	0.00									
160		Мето		0.00				MUS	14-	<u>0</u> 2	-03		-

Memo

DQA:			Date:										DAB.	7
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				AEROSPAC) E
QA Closed:			Date:		····					W	ork Order up	date only		
Work Orde	er:					DISPOSITION			AGA	AINST DE	PARTMENT	PROCESS		
	-				_	Rework	1		Skid-tube Cross	stube]	Water Jet	Engineering]
Part N	lo.					Scrap	1		—	all Fab	Pro	d. Eng. Coor.	Quality	1
	•					Use-as-is	1	Thern	noforming Fini	ishing	Rec/Stor	e/Packaging	Other	1
NCR N	lo.	4				Suspected Unapproved]		Large Fab Comp	oosite]	Supplier]
Root	\neg				Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng			Date	Verification	QC Inspector	
Design	\Box	Dute	otep	~.,		or non comormance	-	ici Eilg					Доморозо	
Doc/Data														
Equip/Tooling							İ						1	
Handling/Pre														
Material														
Operator					1			•						
Offset/Setup														
Process														
Supplier														
Training														
Transport														
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							FA	ULT CA	TEGORY					
Landi	ng (ł			_	General	_	1		_	1	٣		
		Bending			<u> </u>	Bend	<u> </u>	4	Program	<u> </u>	Outside Dim		Pressure/Forced	
		Centre No	ot Concer	ntric	_	BOM/Route		Grain			Over/Under	-	Set-up	
		Cracks			_	Broken/Damage/Defect	\vdash	Hardwa		. -	Part Incorred	 -	Temperature/Cure	,
		Crimp/Kii	nk/Ripple	/Wave	<u> </u>	Burrs	\vdash	1	ion Incomplete/Unqualifie	ed	Part Lost/Mi	ssing	Weld	
t .	_	Cuffs			-	Contamination	\vdash	4	tions Incomplete/Unclear	-	Part Moved	L	Wrong Stock Pulle	a
		Crushing			<u> </u>	Countersink	-	4	gned/off center		Positioned V		Toub are	
		Heat Trea		Tl	\vdash	Cut Too Short	\vdash	Mislab		<u> </u>	Power Loss/	ourge [Other	
	-	Inspectio		iupe	\vdash	Drawing Drill Holos	-	Misrea			· · · · · · · · · · · · · · · · · · ·			
		Marks/Ch				Drill Holes	-	Off-set						
	\vdash	Turning S			-	Finish Fit /Function	\vdash	-	Calibration					
l .	ll	Wave/Tw	vist in Tut	be		Fit/Function		Out of	Sequence			****		

January-15-14 1:17:36 PM

Work Order ID:

111537

Parent Item:

D3575-6

Parent Item Name:

Cargo Floor Protector

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07.07.23

EC verified by:JLM

Comments.	III KCV.A INCW	1884C 07.07.23	LC	vermed by JL	V1								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	3,145.9900	10.666	(12)		Jm1	u-02-3
GE PLASTICS LEXAN S	HEET											<u> </u>	_ `

DQA:			Date:											•	TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					_	AEROSPACE
QA Closed:			Date:							·	Wo	rk Order up	date only		
Work Orde	or.					DISPOSITION				AGAINST	DEP	ARTMENT	PROCESS		
Work Orac	•					Rework	1		Skid-tube	Crosstube	\neg		Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	┪	Quality
	•					Use-as-is			noforming	Finishing			e/Packaging	٦	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
			,										,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	_	
Root					Desc	ription of work order update	1	nitial	Acti		l	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	4	QC Inspector
Design									1		ļ	·			
Doc/Data	-														
Equip/Tooling											•				
Handling/Pre															
Material				!	1										
Operator									•		ŀ				
Offset/Setup Process															
Supplier														١	
Training															
Transport			1								- 1				
Unapproved															
		-			 		FA	ULT CA	TEGORY						
Landi	ng (Gear		·		General									
		Bending				Bend		Folio/I	Program			Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	_	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	cí _		Temperature/Cure
	L	Crimp/Ki	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Un	qualified	Ш	Part Lost/Mi	ssing	_	Weld
		Cuffs				Contamination		4	tions Incomplete/U	Inclear	—	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center		-	Positioned V	-	_	
		Heat Trea			L	Cut Too Short		Mislab		•		Power Loss/	Surge		Other
	<u> </u>	Inspectio		Tube		Drawing	L	Misrea							
		Marks/Cl				Drill Holes	\vdash	Off-set							
ļ		Turning S	•			Finish		4	Calibration						
	1	Wave/Tv	vist in Tul	oe e		Fit/Function		Out of	Sequence						· · · · · · · · · · · · · · · · · · ·

DART AEROSPACE LTD	Work Order:	111537
Description: Cabin Floor Protector	Part Number:	D3575-6
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.005	-		U	JLmoi
3.38	+/-0.030	3.38	-		U	
6.50	+/-0.030	6.50"	_		70 ,	Jknob
26.13	+/-0.030	26.13"	_		T 2	C.
30.13	+/-0.030	30.13"			T	
2.00	+/-0.030	2.00~			TV	
3.50	+/-0.030	3.55	-		V	
14.25	+/-0.030	14.25	_		T	
25.13	+/-0.030	25.,3"	-		T	
29.38	+/-0.030	29.38			T	
30.38	+/-0.030	30.38	-			
31.50	+/-0.030	31.50"	-		T	
1.00	+/-0.030	1.00	-		ν	
4.38	+/-0.030	4.38"			V	
14.50	+/-0.030	14.504			T	
16.00	+/-0.030	16.00	-		1	
23.13	+/-0.030	23.13"			1	
26.88	+/-0.030	26.88	-		1	
27.69	+/-0.030	27.69"	_		1	
1.00	+/-0.030	1.00	_		V	
3.75	+/-0.030	3.75"	_		V	
9.63	+/-0.030	9.63"	-		T T	
16.13	+/-0.030	16.13"	_			
28.06	+/-0.030	26.00"	~		T	
32.15	+/-0.030	32.15"	DAS		1	

Measured by: Jm

Date: 4-02-3

Audited by: 9-89

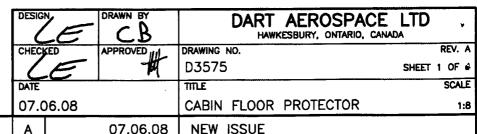
Date: 14/2/3

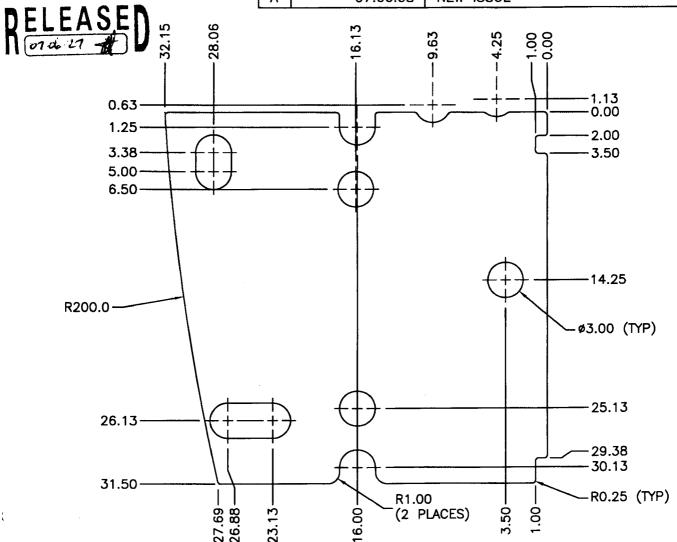
Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	KJ//DD 🚓	







111537 HP 14-01-16

D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

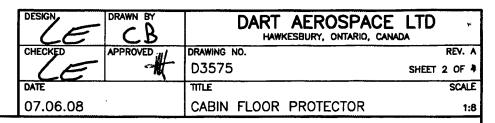
NOTES:

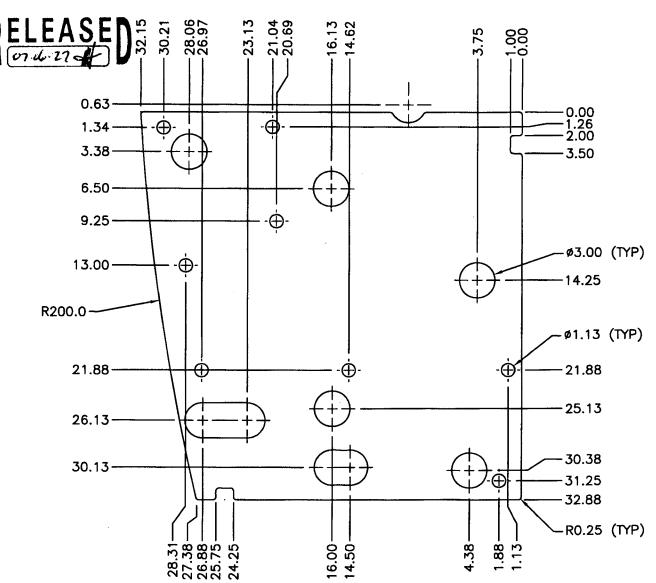
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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D3575-3 CABIN FLOOR PROTECTOR

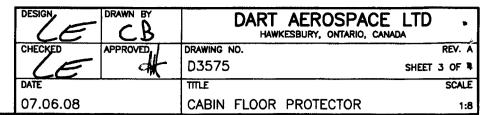
NOTES:

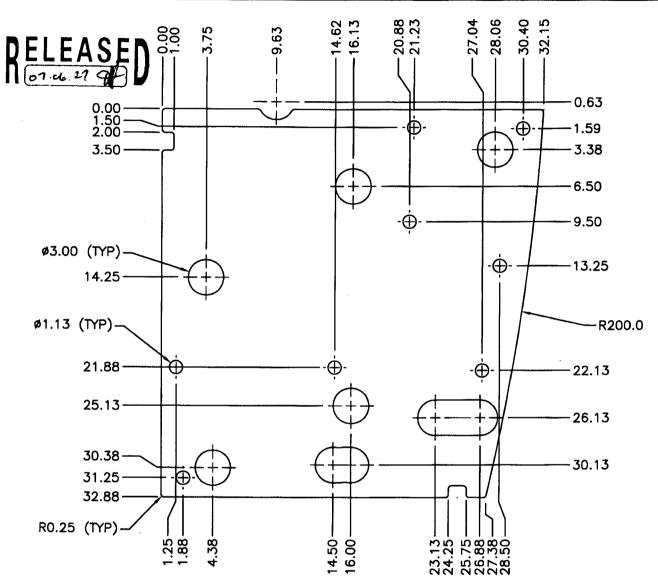
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- CHECK PER TEMPLATE DT8967

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D3575-4 CABIN FLOOR PROTECTOR

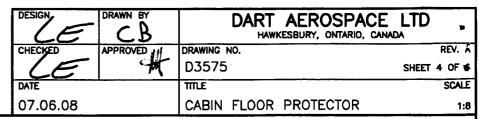
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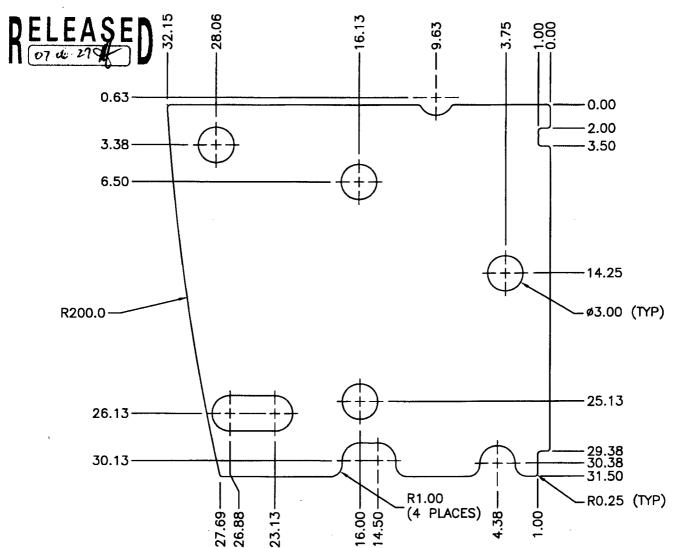
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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